

**Durethan® BKV115H2.0 000000 DUS008**  
**PA6-I-GF15**

Envalior

Injection Molding, 15% Glass Reinforced, Heat Stabilized, Improved Impact

ISO 1043 PA6-I-GF15

| Rheological properties      | dry / cond | Unit | Test Standard   |
|-----------------------------|------------|------|-----------------|
| <b>ISO Data</b>             |            |      |                 |
| Molding shrinkage, parallel | 0.5 / *    | %    | ISO 294-4, 2577 |
| Molding shrinkage, normal   | 0.6 / *    | %    | ISO 294-4, 2577 |

| Mechanical Properties                   | dry / cond  | Unit              | Test Standard |
|-----------------------------------------|-------------|-------------------|---------------|
| <b>ISO Data</b>                         |             |                   |               |
| Tensile Modulus                         | 5900 / 3000 | MPa               | ISO 527       |
| Stress at Break                         | 115 / 60    | MPa               | ISO 527       |
| Strain at Break                         | 4 / 12      | %                 | ISO 527       |
| Impact Strength (Charpy), +23°C         | 65 / 100    | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Impact Strength (Charpy), -30°C         | 45 / 45     | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Notched Impact Strength (Charpy), +23°C | - / 15      | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Notched Impact Strength (Charpy), -30°C | - / 10      | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Puncture - maximum force, +23°C         | 710 / -     | N                 | ISO 6603-2    |
| Puncture - maximum force, -30°C         | 590 / -     | N                 | ISO 6603-2    |
| Puncture energy, +23°C                  | 3 / -       | J                 | ISO 6603-2    |
| Puncture energy, -30°C                  | 2.2 / -     | J                 | ISO 6603-2    |
| Flexural Modulus (23°C)                 | 5200 / 2900 | MPa               | ISO 178       |
| Notched Impact Strength (Izod), 23°C    | 10 / 15     | kJ/m <sup>2</sup> | ISO 180/1A    |
| Notched Impact Strength (Izod)          | 10 / 10     | kJ/m <sup>2</sup> | ISO 180/1A    |
| Temperature                             | -30         | °C                | -             |
| Impact Strength (Izod), 23°C            | 55 / 85     | kJ/m <sup>2</sup> | ISO 180/1U    |

| Thermal Properties                          | dry / cond | Unit  | Test Standard  |
|---------------------------------------------|------------|-------|----------------|
| <b>ISO Data</b>                             |            |       |                |
| Melting Temperature (10°C/min)              | 221 / *    | °C    | ISO 11357-1/-3 |
| Temp. of deflection under load (1.80 MPa)   | 190 / *    | °C    | ISO 75-1/-2    |
| Temp. of deflection under load (0.45 MPa)   | 215 / *    | °C    | ISO 75-1/-2    |
| Coeff. of Linear Therm. Expansion, parallel | 30 / *     | E-6/K | ISO 11359-1/-2 |
| Coeff. of Linear Therm. Expansion, normal   | 100 / *    | E-6/K | ISO 11359-1/-2 |
| Burning Behav. at 1.5 mm Nom. Thickn.       | HB / *     | class | UL 94          |
| Thickness tested                            | 1.5 / *    | mm    | -              |

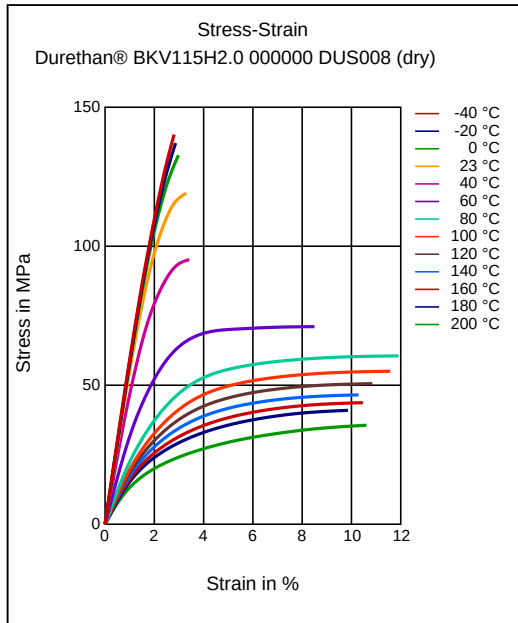
| Other Properties | dry / cond | Unit              | Test Standard |
|------------------|------------|-------------------|---------------|
| <b>ISO Data</b>  |            |                   |               |
| Density          | 1230 / -   | kg/m <sup>3</sup> | ISO 1183      |

| Test specimen production            | Value | Unit | Test Standard |
|-------------------------------------|-------|------|---------------|
| <b>ISO Data</b>                     |       |      |               |
| Injection Molding, melt temperature | 280   | °C   | ISO 294       |
| Injection Molding, mold temperature | 80    | °C   | ISO 294       |

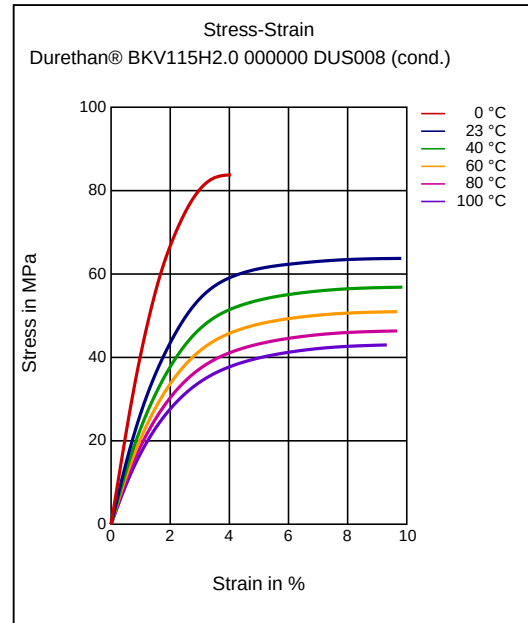
| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---------------------------------------------|-----------|------|---------------|
| Pre-drying - Temperature                    | 80        | °C   | -             |
| Pre-drying - Time                           | 2 - 6     | h    | -             |
| Processing humidity                         | ≤0.12     | %    | -             |
| Melt temperature                            | 260 - 290 | °C   | -             |
| Mold temperature                            | 80 - 100  | °C   | -             |

## Diagrams

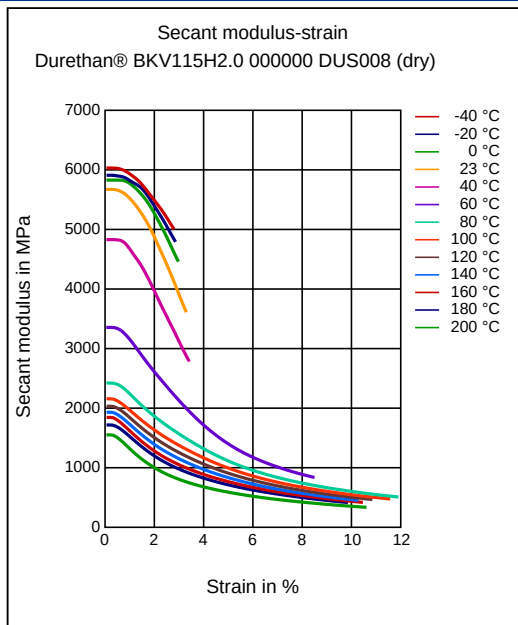
### Stress-strain



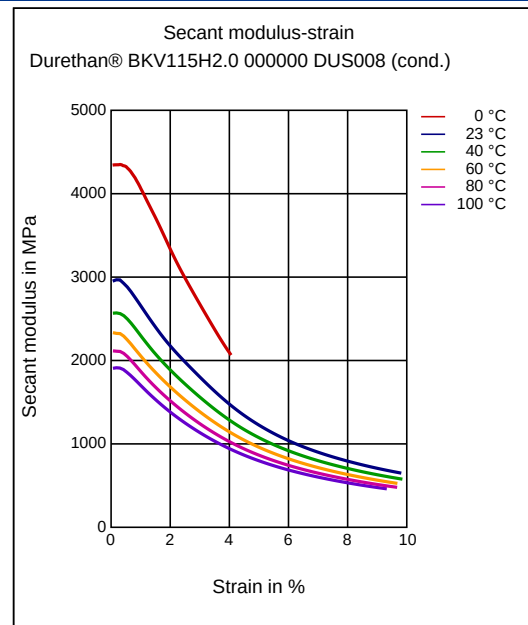
### Stress-strain



### Secant modulus-strain



### Secant modulus-strain



## Characteristics

### Processing

Injection Molding

### Delivery form

Pellets

### Injection Molding PREPROCESSING

### Special Characteristics

Impact modified, Heat aging stabilized

Residual moisture content: 0.03 - 0.12%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

#### PROCESSING

Melt temperature (Tmin - Tmax): 260 - 290 °C

Mold temperature: 80 - 100 °C

#### Disclaimer

##### Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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